

ABSTRACT:

5 A method of controlling a process of electrochemically machining an electrically conductive workpiece employing the spectral composition of the measured voltage within a predetermined measuring period such as induced by an applied current between the electrically conductive workpiece and an electrode tool. A process of electrochemically machining employing a material removing step with electric current supplied continuously and an a workpiece shaping step with electric current supplied intermittently. An advantageous embodiment employs extreme short pulses.

Fig. 20

PHNL000188-44704